

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
12 December 2002 (12.12.2002)

PCT

(10) International Publication Number
WO 02/099247 A1

(51) International Patent Classification⁷: **E21B 33/13**,
41/00, 29/10

(21) International Application Number: PCT/EP02/06320

(22) International Filing Date: 5 June 2002 (05.06.2002)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
01202121.8 5 June 2001 (05.06.2001) EP

(71) Applicant (for all designated States except CA, US): **SHELL INTERNATIONALE RESEARCH MAATSCHAPPIJ B.V.** [NL/NL]; Carel van Bylandtlaan 30, NL-2596 HR The Hague (NL).

(71) Applicant (for CA only): **SHELL CANADA LIMITED** [CA/CA]; 400, 4th Avenue S.W., Calgary, Alberta T2P 2H5 (CA).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **BOSMA, Martin, Gerard, Rene** [NL/NL]; Volmerlaan 6, NL-2288 GD Rijswijk (NL). **CORNELISSEN, Erik, Kerst** [NL/NL];

Volmerlaan 6, NL-2288 GD Rijswijk (NL). **DIMITRI-ADIS, Klisthenis** [GR/NL]; Volmerlaan 8, NL-2288 GD Rijswijk (NL). **PETERS, Mike** [CA/NL]; Volmerlaan 8, NL-2288 GD Rijswijk (NL). **WORRALL, Robert, Nicholas** [GB/NL]; Volmerlaan 6, NL-2288 GD Rijswijk (NL).

(81) Designated States (national): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZM, ZW.

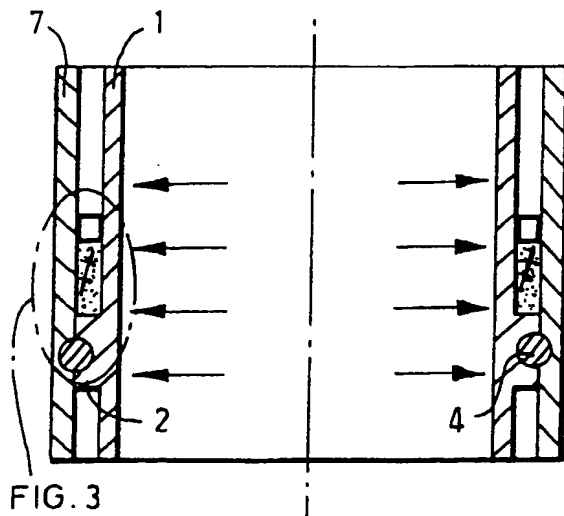
(84) Designated States (regional): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, MI, MR, NE, SN, TD, TG).

Published:

— with international search report

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

(54) Title: IN-SITU CASTING OF WELL EQUIPMENT



(57) Abstract: A method is provided of in-situ casting well equipment wherein a metal is used which expands upon solidification, the method comprising the steps of: placing a body of said metal in a cavity in the well; bringing said body at a temperature above the melting point of the metal; cooling down said body to below the melting point of the metal, thereby solidifying the metal of said body in the cavity.

WO 02/099247 A1

IN-SITU CASTING OF WELL EQUIPMENT

Background of the Invention

The invention relates to a method for in-situ casting of well equipment.

5 It is standard practice to cast cement linings around well casings to create a fluid tight seal between the well interior and surrounding formation.

A disadvantage of this and many other in-situ casting techniques is that the cement or other solidifying substance shrinks during solidification or curing as a
10 result of higher atomic packing due to hydration and/or phase changes.

It is an object of the present invention to alleviate this drawback of the known in-situ casting techniques.

15 It is another object of the present invention to provide a method for filling in relatively inaccessible downhole voids in-situ, such as annuli between (expandable) well tubulars, threads, leaks, pore
1 openings, gravel packs, fractures or perforations.

20 It is a further object of the invention to provide a method of creating a reliable and strong seal in a hydrocarbon fluid well.

Summary of the Invention

In accordance with the invention an expanding alloy is used, which expands upon solidification and which has
25 a melting temperature that is higher than the maximum anticipated well temperature, which alloy is placed within a cavity in the well and held at a temperature above the melting point of the alloy, whereupon the alloy is cooled down to the ambient well temperature and
30 thereby solidifies and expands within the cavity.

Preferably the expanding alloy comprises Bismuth. Alternatively the expanding alloy comprises Gallium or Antimony.

5 It is observed that it is known to use Bismuth compositions with a low melting point and which expand during cooling down from US patents Nos. 5,137,283; 4,873,895; 4,487,432; 4,484,750; 3,765,486; 3,578,084; 3,333,635 and 3,273,641.

10 However, in technologies known from these prior art references no well equipment made up of a Bismuth alloy is cast in-situ.

15 In accordance with the invention it is preferred that the alloy is lowered through the well within a container in which the temperature is maintained above the melting temperature of the alloy and an exit of the container is brought in fluid communication with the cavity whereupon the molten alloy is induced to flow through the exit from the container into the cavity.

20 Alternatively, the alloy is placed in a solid state in or adjacent to the cavity and heated downhole to a temperature above the melting temperature of the alloy whereupon the heating is terminated and the alloy is permitted to solidify and expand within the cavity.

25 Optionally, the cavity is an annular cavity between a pair of co-axial well tubulars. Such cavity suitably has near a lower end thereof a bottom or flow restriction that inhibits leakage of molten alloy from the cavity into other parts of the wellbore.

30 Suitably, the annular cavity is formed by an annular space between overlapping sections of an outer well tubular and an expanded inner well tubular. The flow restriction can, for example, be formed by a flexible sealing ring located near a lower end of the annular space.

In such case it is preferred that a ring of an expanding alloy is positioned above a pre-expanded section of an expandable well tubular and around the outer surface of said tubular and that the ring of
5 expanding alloy comprises an array of staggered non-tangential slots or openings which open up in response to radial expansion of the tubular. Alternatively the ring may be a split ring with overlapping ends. Upon or as a result of the heat generated by expansion of the tubular
10 the ring will melt and solidify again and provide an annular seal.

To create a very strong seal in the annular cavity it is preferred that said body is a first body, the first body being axially restrained in the cavity by a second
15 body of metal which expands upon solidification, and wherein the metal of the second body solidifies at a higher temperature than the metal of the first body, the method further comprising:

- placing the second body in the annular cavity axially
20 displaced from the first body;
- melting said bodies by raising the temperature of said bodies;
- solidifying said bodies by lowering the temperature of said bodies, whereby the metal of the second body
25 solidifies before the metal of the first body thereby axially restraining the first body.

Thus, in accordance with the present invention the special expanding properties of Bismuth, Gallium or Antimony and/or alloys thereof may be utilized to seal
30 the cavities within well tubulars, the annuli between co-axial well tubulars, or the annulus between a well casing and the formation, or any small gap or orifice within the well or surrounding formation such as threads, leaks, pore openings, gravel packs, fractures or perforations.

Description of preferred embodiments

The invention will be described in more detail with reference to the accompanying drawings in which:

5 Fig. 1 shows a longitudinal sectional view of an expandable tubular around which two expandable alloy rings are arranged;

Fig. 2 shows the tubular and rings of Fig. 1 after expansion thereof within another tubular;

10 Fig. 3 shows in detail the annular space of Fig. 2 after melting of the alloy rings; and

Fig. 4 illustrates how the upper expandable alloy ring expands upon solidification within the annulus and how subsequently the lower ring expands upon solidification.

15 Referring to Figs. 1 and 2 there is shown an expandable tubular 1, which is provided with a ring-shaped external shoulder 2. The shoulder 2 has a ring-shaped recess in which an O-ring 4 is arranged. Above the shoulder 2a ring 5 is made of a Bismuth alloy is
20 arranged.

The metal Bismuth, Atomic No. 83 and its alloys containing at least 55% by weight Bismuth expand whilst transiting from the molten into the solid phase.

25 Pure Bismuth (MP = 271 °C) expands by 3.32 vol. % on solidification in ambient conditions, whilst its typical eutectic alloys such as e.g. Bi₆₀Cd₄₀ (MP = 144 °C) typically expand by 1.5 vol. %.

30 In accordance with the invention the special expanding properties of Bismuth (and its alloys) may be utilized to seal the small annular space between an outer well tubular 7 and an inner expanded tubular 1 as shown in Fig. 2.

35 A ring 5 of Bismuth or Bismuth-alloy material is positioned on an upset shoulder 2 of a pre-expanded expandable tubular 1. The ring 5 may be continuous or

slotted to permit expansion. The shoulder 2 can be perpendicular to the pipe axis, or tilted at an angle to permit sealing in a deviated well.

5 An additional upper ring 6 of Bismuth or Bismuth-alloy material with a melting point that is higher than ring 5 and with a density which is less than ring 5 is placed inside a flexible, temperature-resisting plastic or rubber bag (e.g. oven-safe plastic wrap) 8 and the combination of bag and ring 6 are placed on top of ring 10 5, such that the tubular 1, when vertical has from top to bottom: ring 6, ring 5 and then the upset shoulder 2. Rings 5 and 6 may also be continuous or slotted to permit expansion.

15 The Bismuth rings 5 and 6 and pre-expanded tubular 1 are run into the well in a normal manner. The casing is expanded using known pipe expansion techniques until the shoulder 2, O-ring 4 or additional seal sections are made to be in contact with the outer tubular 7. Additional seal sections may be included as part of the tubular, in 20 the form of a lip or upset, or as an additional part, such as an elastomeric O-ring 4.

Once the tubular 1 is expanded so that the outer diameter of the expanded tubular 1 is in contact with the outer tubular 7, or any other external sealing mechanisms 25 of the tubular 1 are in contact with the outer tubular 7, heat is applied. Heat is applied from the inside of the tubular 1 using a chemical source of heat, electric (resistive or inductive) heater, or through conductions of a hot liquid inside the tubular 1. This heat will 30 increase the temperature of both Bismuth or Bismuth alloy rings until eventually both rings will melt and sag to the lowest point in the annulus by gravity.

The metal from ring 5 will take the lowest portion of the annular space, followed by the metal from ring 6,

though the latter will remain contained by the plastic bag 8.

5 The heat source will be removed, or heating will cease and the temperature in the wellbore will slowly lower to its original temperature. Ring 6 will be the first to freeze and will expand (mostly in the vertical direction), however, some outward force on the tubular 1 will help provide a frictional resistance to the expansion of ring 6. This may be aided by roughness or
10 ledges being machined into either the outer or inner tubular 7 or 1 before running in hole. Ring 5 will solidify and expand following the solidification of ring 6, and being constrained will expand with a great sealing force in all directions, providing a tight metal-
15 to-metal seal between the tubulars 1 and 7 as is illustrated in Fig. 4.

The Bismuth-alloy may be lowered into the well in a solid or liquid phase or may be created in-situ through an exothermic reaction.

20 The latter method may include the following steps. Bi_2O_3 and a highly reactive metal species, such as Al, are combined in a powdered form in a 1:1 ratio, such that they have a very high surface area per volume. This powder is deposited into the desired location via a
25 coiled tubing or dump-bailer assembly. Subsequently, the powder (which could be pelletised or carefully sintered) is "ignited" by the discharge of a capacitor or other suitable electric or chemical method. The Al will react with the oxygen in the Bi_2O_3 , forming nearly pure Bi,
30 which will be molten due to the exothermic nature of this reaction and an Al_2O_3 low density solid slag will float (harmlessly) on the surface of the Bi pool.

Alternatively, if the Bismuth-alloy material is lowered in a solid phase into a well then the Bismuth-
35 alloy material may form part of the completion or casing

assembly (in the case of an annular sealing ring) or be positioned into the well through coiled tubing in the form of pellets or small pieces. In either case, surface cleaning of any pipe-sections to be sealed by the expanding Bismuth-alloy may be done through jetting or chemical means.

Subsequent to placement, heat is applied through for example electric resistive and/or induction heating, super-heated steam injection, and/or an exothermic chemical reaction. The generated heat will melt the alloy, allowing a liquid column to form, whereupon the liquid column is allowed to cool down and the Bismuth-alloy will solidify and expand.

If the Bismuth-alloy is lowered in a substantially liquid phase into the well then the alloy may be melted on surface and carried to the desired downhole location via a double-walled insulated and/or electrically heated coiled tubing.

If certain low-melting point alloys are used, such as Bi-Hg alloys, it is possible to create additions (e.g. Cu) to these alloys which act as "hardeners". In this embodiment, liquid alloys with melting points lower than the well temperature are deposited in situ via coiled tubing. This could be achieved by gravity or with the aid of pressure facilitated through the action of a piston, or surface provider (pump). Subsequently, solid pellets of an alloying element can be added to the "pool"- if well selected, these can create a solid Bismuth-alloy.

A number of suitable downhole applications of expandable Bismuth-alloys is summarized below:

- An expandable well abandonment plug: A liquid column of a suitable molten Bismuth-alloy may be created on top of a conventional mechanical or cement plug within a casing string. The melting point of the alloy used is selected greater than the equilibrium well temperature at

that depth. Thus, the liquid Bismuth-alloy will solidify within the casing and the resultant expansion will lock the Bismuth-alloy plug-in place and form a gas-tight seal separating the lower section of the casing from that portion above.

- An expandable annular seal plug: A liquid column of suitable Bismuth-alloy may be created on top of, or within the annular cement column between two casing strings, or liner and casing strings. An annular seal will be created in a manner similar to that described for the abandonment plug.

- A temporary reversible plug - used, for example to temporarily shut off a multilateral well's lateral.

- An external shut-off medium - A Bismuth-alloy may be injected into perforations, matrix rock, or fracture as a shut-off material. The alloy could create a kind of artificial casing material in one embodiment.

- A repair medium - A Bismuth-alloy could be used to repair sand-screens, leaking packers, hanger seals, or tubing or casing within a well.

- An alternate packer or liner hanger seal - Similarly to the annular seal plug, reversible packers or liner hanger seals may be created. In these cases, Bismuth-alloys could have their solidification expansion constrained by elastomer seals, or higher melting point (and thus solid sooner) Bismuth-alloys. These may be specifically applicable to the monobore well concept. Similar seals could be used for wellhead seals.

A more detailed description of a number of suitable Bismuth, Gallium or other expandable alloys will be provided below.

A wide selection of the expandable Bismuth, Gallium alloys may be used for each of the downhole applications described above. In addition to pure Bismuth the following binary alloys as detailed in paragraphs a)-f)

below are considered to be the most likely building blocks from which ternary, quaternary and higher order alloys could be derived.

- 5 a) $\text{Bi}_{100-x}\text{Sn}_x$: where $x = 0$ to 5. This will produce a solid solution alloy with a melting point $> 141^\circ\text{C}$. Small amounts of additional elements, such as Sb, In, Ga, Ag, Cu and Pb are possible. This alloy possesses the ability to be strengthened by a post-solidification precipitation hardening where an Sn-rich phase will be precipitated within the Bi-rich matrix. This alloy will present the largest expansion on solidification. Industrial examples of these alloys include: pure Bismuth, (sold as Ostalloy 520); $\text{Bi}_{95}\text{Sn}_5$, (sold as Cerrocast 9500-1 or Ostalloy 524564).
- 10
- 15 b) $\text{Bi}_{100-x}\text{Cu}_x$: where $x = 0$ to 45. These alloys are considered for high temperature applications, such as in geothermal wells. The melting point of these alloys ranges from 271 to about 900°C .
- 20 c) $\text{Bi}_{100-x}\text{Hg}_x$: where $x = 0$ to 45. These alloys are considered for lower temperature applications. The melting point of these alloys ranges from 150 to 271°C . These alloys will be less desirable due to the toxicity of Hg, however, other factors may influence this.
- 25 d) $\text{Bi}_{100-x}\text{Sn}_x$: where $x = 5$ to 42. These alloys have melting points ranging from 138 to 271°C . However, unless supercooled, the last-to-freeze phase will solidify at 138°C (the eutectic temperature). This alloy is very attractive due to its melting point, since this temperature would be applicable for most well
- 30 applications. Examples of commercial alloys include: Ostalloy 281, Indalloy 281 or Cerrotru 5800-2.

Lead (Pb) is often included according to $\text{Bi}_{100-x-y}\text{Sn}_x\text{Pb}_y$ (where $x+y < 45$ - generally $y < 6$). This results in an alloy with a lower melting point than

binary Bi-Sn. Examples of commercial alloys include: Cerrobaze 5684-2, or 5742-3; Ostalloy 250277, or 262271.

Additional alloying additions can be made, which produce a multiphased, but very low melting point alloy, such as "Wood's Metal" (typically: $\text{Bi}_{50}\text{Pb}_{25}\text{Sn}_{12.5}\text{Cd}_{12.5}$); there is a wide variety of these metals. However, the majority of these alloys have melting points too low (e.g. Dalton Metal: $\text{Bi}_{60}\text{Pb}_{25}\text{Sn}_{15}$ has a melting point of 92 °C, Indalloy 117 has a melting point of 47 °C) to be of interest in well applications, with the exception noted above regarding cool liquid placement.

e) $\text{Bi}_{100-x}\text{Pb}_x$: where $x = 0$ to 44.5. These alloys could be used for lower melting points desired, since the eutectic temperature is at 124 °C. Additions of Indium (In), Cadmium (Cd) or Tin (Sn) are common, and all further reduce the melting point. The binary eutectic is sold by Cerro Metal Products as "Cerrobaze".

f) Others: $\text{Bi}_{100-x}\text{Xn}_x$: where $x = 0$ to 4.5. (Eutectic point at $x = 4.5$.) These alloys are considered for higher temperature applications since their melting points range from 257 to 271 °C. $\text{Bi}_{100-x}\text{Cd}_x$: where $x = 0$ to 40. (Eutectic point at $x = 4.5$.) Melting point of eutectic 144 °C. $\text{Bi}_{100-x}\text{In}_x$: with $x < 33$. Often includes other elements to have very low (< 100 °C) melting points (for example Indalloy 25).

Thus, it will be apparent to those skilled in the art that a variety of Bismuth, Gallium and other expandable alloys are suitable for in-situ casting of seals and/or other components for use in well construction, workover, treatment and abandonment operations.

Examples

1) An experiment was carried out to verify that the expansion behaviour of Bismuth alloys is not limited to atmospheric conditions. A $\text{Bi}_{58}\text{Sn}_{42}$ (Bismuth-Tin) alloy was solidified in a pressurized chamber at 400 bar

pressure. The pressurized chamber formed part of an experimental device which is described in SPE paper 64762 ("Improved Experimental Characterization of Cement/Rubber Zonal Isolation Materials", authors M G Bosma, E K Cornelissen and A Schwing). The experiment indicated that under the test conditions the alloy expanded by 1.41% by volume.

2) Another sample of a Bi₅₈Sn₄₂ alloy was cast into a dirty (i.e. coated with API Pipe Dope) piece of a tubular with an internal diameter of 37.5 cm and subsequently allowed to be solidified into a plug having a length of 104.6 mm within the tubular to test the sealing ability of the alloy. Water pressure was applied to the tubular section at one end of the solidified plug and the differential pressure was measured across the plug. The water pressure was gradually increased and the plug was able to withstand a differential pressure of 80 bar before leaking commenced.

C L A I M S

1. A method of in-situ casting well equipment wherein a metal is used which expands upon solidification, the method comprising the steps of:

- placing a body of said metal in a cavity in the well;
- 5 - bringing said body at a temperature above the melting point of the metal;
- cooling down said body to below the melting point of the metal, thereby solidifying the metal of said body in the cavity.

10 2. The method of claim 1, wherein said metal is an alloy comprising Bismuth.

3. The method of claim 1 or 2, wherein said body is lowered through the well in a container in which the temperature is maintained above the melting temperature
15 of the metal and an outlet of the container is brought in fluid communication with the cavity whereupon the molten metal is induced to flow via said outlet into the cavity.

4. The method of claim 1 or 2, wherein said body is placed in a solid state in or adjacent the cavity and
20 heated downhole to a temperature above the melting temperature of the metal whereupon the heating is terminated and the metal is allowed to solidify and thereby to expand within the cavity.

5. The method of any one of claims 1-4, wherein the
25 cavity is an annular cavity between a pair of co-axial well tubulars.

6. The method of claim 5, wherein the annular cavity is formed by an annular space between overlapping sections of an outer well tubular and an expanded inner well
30 tubular.

7. The method of claim 5 or 6, wherein the cavity has near a lower end a bottom or flow restriction that inhibits leakage of molten metal from the cavity into other parts of the wellbore.

5 8. The method of claim 7, wherein the flow restriction is formed by a flexible sealing ring which is located near a lower end of the annular space.

9. The method of claim 8, wherein the flexible sealing ring comprises an array of staggered non-tangential slots or openings which open up in response to radial expansion of the tubular.

10 10. The method of any one of claims 5-9, wherein said body is a first body, the first body being axially restrained in the cavity by a second body of metal which expands upon solidification, and wherein the metal of the second body solidifies at a higher temperature than the metal of the first body, the method further comprising:

- 15 - placing the second body in the annular cavity axially displaced from the first body;
- 20 - melting said bodies by raising the temperature of said bodies;
- solidifying said bodies by lowering the temperature of said bodies, whereby the metal of the second body solidifies before the metal of the first body thereby
- 25 axially restraining the first body.

11. The method substantially as described hereinbefore with reference to the accompanying drawings.

Fig.1.

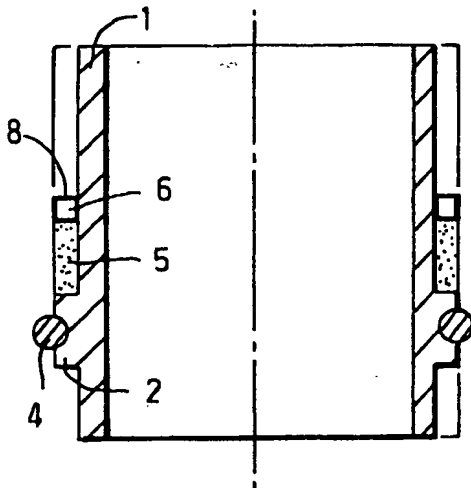


Fig.2.

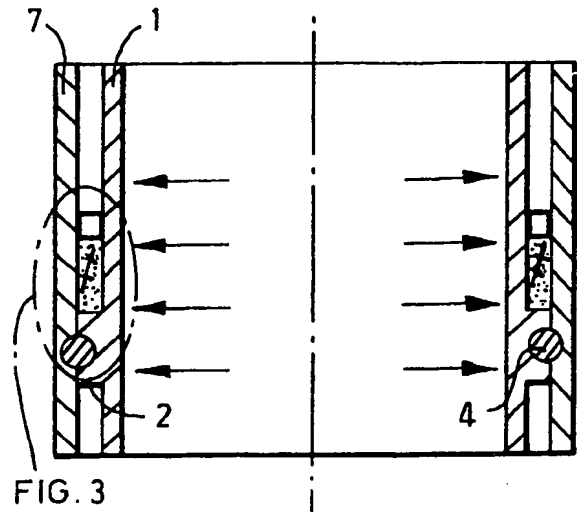


Fig.3.

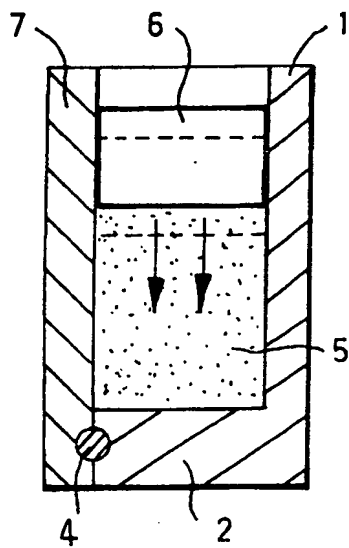
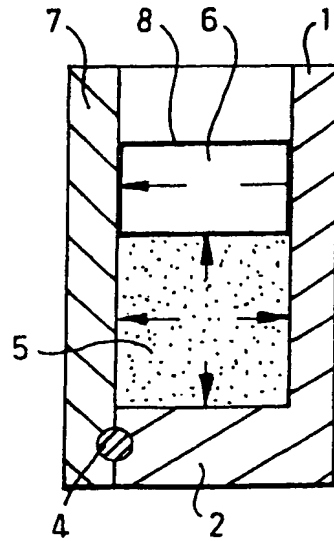


Fig.4.



INTERNATIONAL SEARCH REPORT

International Application No

PCT/EP 02/06320

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 E21B33/13 E21B41/00 E21B29/10

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 E21B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	FR 2 780 751 A (DRILLFLEX) 7 January 2000 (2000-01-07) page 2, column 6, paragraph 18; claim 1	1
A	US 5 295 541 A (NG RICKY C ET AL) 22 March 1994 (1994-03-22) column 1, line 54 - column 2, line 12 column 2, line 22 - line 29	1
A	WO 93 05268 A (ALTMAYER HANS JOACHIM) 18 March 1993 (1993-03-18) page 2, line 3 - line 22 page 8, line 9 - line 15	1
A	US 4 873 895 A (TAYLOR MALCOLM R ET AL) 17 October 1989 (1989-10-17) column 2, line 36 - line 38	1

☐ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

* Special categories of cited documents :

A document defining the general state of the art which is not considered to be of particular relevance

E earlier document but published on or after the international filing date

L document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

O document referring to an oral disclosure, use, exhibition or other means

P document published prior to the international filing date but later than the priority date claimed

T later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

X document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

Y document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

Z document member of the same patent family

Date of the actual completion of the international search

2 August 2002

Date of mailing of the international search report

30/08/2002

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2.
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3018

Authorized officer

Bellingacci, F

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/EP 02/06320

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
FR 2780751	A	07-01-2000	FR 2780751 A1	07-01-2000
US 5295541	A	22-03-1994	US 5404950 A	11-04-1995
			US 5377757 A	03-01-1995
			US 5531272 A	02-07-1996
WO 9305268	A	18-03-1993	WO 9305268 A1	18-03-1993
US 4873895	A	17-10-1989	GB 2211873 A , B	12-07-1989

**This Page is Inserted by IFW Indexing and Scanning
Operations and is not part of the Official Record**

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images include but are not limited to the items checked:

- ☐ BLACK BORDERS
- ☐ IMAGE CUT OFF AT TOP, BOTTOM OR SIDES
- ☒ FADED TEXT OR DRAWING
- ☐ BLURRED OR ILLEGIBLE TEXT OR DRAWING
- ☐ SKEWED/SLANTED IMAGES
- ☐ COLOR OR BLACK AND WHITE PHOTOGRAPHS
- ☐ GRAY SCALE DOCUMENTS
- ☐ LINES OR MARKS ON ORIGINAL DOCUMENT
- ☐ REFERENCE(S) OR EXHIBIT(S) SUBMITTED ARE POOR QUALITY
- ☐ OTHER: _____

IMAGES ARE BEST AVAILABLE COPY.

As rescanning these documents will not correct the image problems checked, please do not report these problems to the IFW Image Problem Mailbox.